

# Work Order ID 63887

Thursday, November 18, 2010 10:11:01 AM

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Item ID: D4271-011

Accept

Revision ID: PRELIM

Item Name: Fwd Beam Assembly

Start Date: 11/18/2010 Start Qty: 2.00

Required Date: 11/22/2010 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

PRELIMINARY ISSUE

Approvals:

Process Plan: *mf*

Date: 10-11-18 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4271	PA1								

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Pick and Assemble as per dwg

*B*

10.11.14

*Q*

*PTO*

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*Scot/22*

*-inspector + Pa*

*Don only*

120

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00






Packaging



*test*


**Work Order ID 63887**

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Item ID: D4271-011 Accept  Setup Start   
Revision ID: PRELIM Stop   
Item Name: Fwd Beam Assembly  
Start Date: 11/18/2010 Start Qty: 2.00  Cust Item ID:  
Required Date: 11/22/2010 Req'd Qty: 2.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

*test. by PTO*  
*Deviation by PTO*  
10-11-23  
D4271-1  
POSITIVE RECALL  
EFFECTIVE \_\_\_\_\_ AUTH \_\_\_\_\_  
RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

*MUF*  
*10-11-30*

# Picklist Print

Page 1

Thursday, November 18, 2010 10:11:01 AM

Work Order ID: 63887

Parent Item: D4271-011

Parent Item Name: Fwd Beam Assembly











Start Date: 11/18/2010

Required Date: 11/22/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D4149-5 Eyebolt Stud		Manufactured	No			100	Each	9.0000	1	2			
<div>  <span>B/N 60790</span> </div> <div>  <span>B60790 10/11/19 SP</span> </div>													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				9					
				61234				9					
✓ D4274-1 Plate, Fwd Support		Manufactured	No			100	Each	0.0000	2	4			
<div>  <span>B63884</span> </div> <div>  <span>AB 10.11.19 (2)</span> </div>													
✓ D4275-1 Fwd Beam		Manufactured	No			100	Each	0.0000	1	2			
<div>  <span>B63881</span> </div> <div>  <span>AB 10.11.19 (1)</span> </div>													
✓ D4281-1 Spacer		Manufactured	No			100	Each	0.0000	1	2			
<div>  <span>B63886</span> </div> <div>  <span>AB 10.11.19 (1)</span> </div>													
AN3C12A Bolts		Purchased	No			100	Each	61.0000	8	16			
<div>  </div> <div>  <span>AB 10.11.19</span> </div>													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST351				61					
				112314				8					
				114761				11					
				116022				42					

# Picklist Print

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Thursday, November 18, 2010 10:11:01 AM

Work Order ID: 63887



Parent Item: D4271-011



Parent Item Name: Fwd Beam Assembly

Start Date: 11/18/2010

Required Date: 11/22/2010

Start Qty: 2.00

Required Qty: 2.00

MS20615-4M18

Purchased

No

100

Each

391.0000

8

16



Rivet



10-11-19

(8)

LocationLoc QtyLoc Code

ST323

391

114808

152

115037

239

MS21043-3

Purchased

No

100

Each

2,226.000

8

16



Nut



10-11-19

(8)

LocationLoc QtyLoc Code

FG

76

103691

76

ST301

2150

112314

2150

NAS1149C0332R

Purchased

No

100

Each

4,239.000

16

32



Washer



10-11-19

(16)

LocationLoc QtyLoc Code

ST297

4239

113524

10

113737

150

115000

125

115698

35

115832

1919

116025

2000

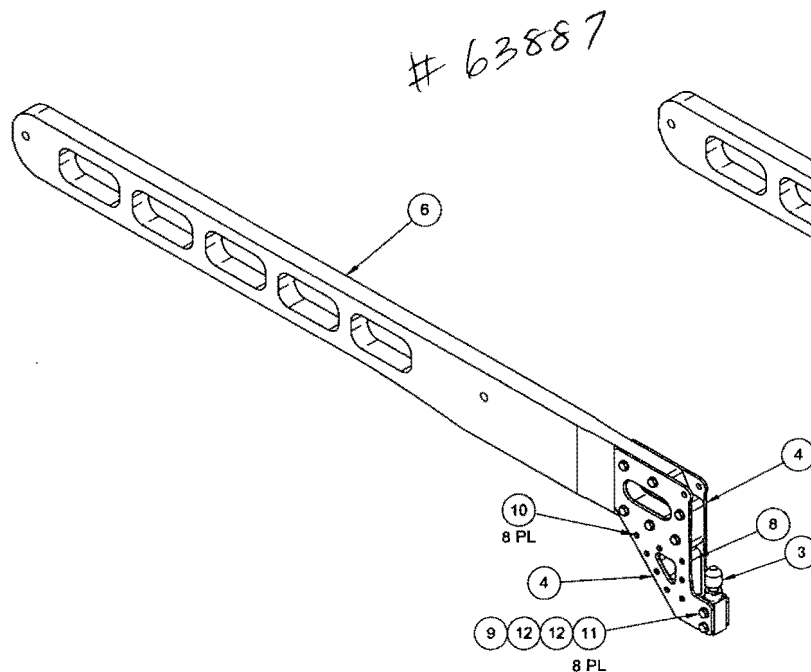
16

Thursday, November 18, 2010 10:11:01 AM

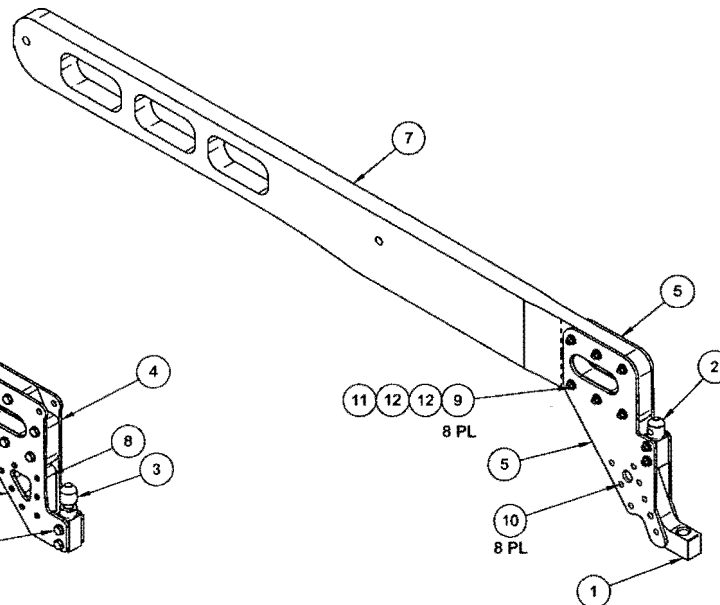
Shop Packet Print

Page 2

ITEM	QTY -011	QTY -013	PART NUMBER	DESCRIPTION
			D4271-011	FWD BEAM ASSY
			D4271-013	AFT BEAM ASSY
1		1	D4148-3	STUD RECEIVER
2		1	D4148-5	EYEBOLT STUD
3	1		D4148-5	EYEBOLT STUD
4	2		D4274-1	PLATE, FWD SUPPORT
5		2	D4274-3	PLATE, AFT SUPPORT
6	1		D4275-1	FWD BEAM
7		1	D4276-1	AFT BEAM
8	1		D4281-1	SPACER
9	8	8	AN3C12A	BOLT
10	8	8	MS20815-4M18	RIVET
11	8	8	MS21043-3	NUT
12	16	16	NAS1149C0332R	WASHER



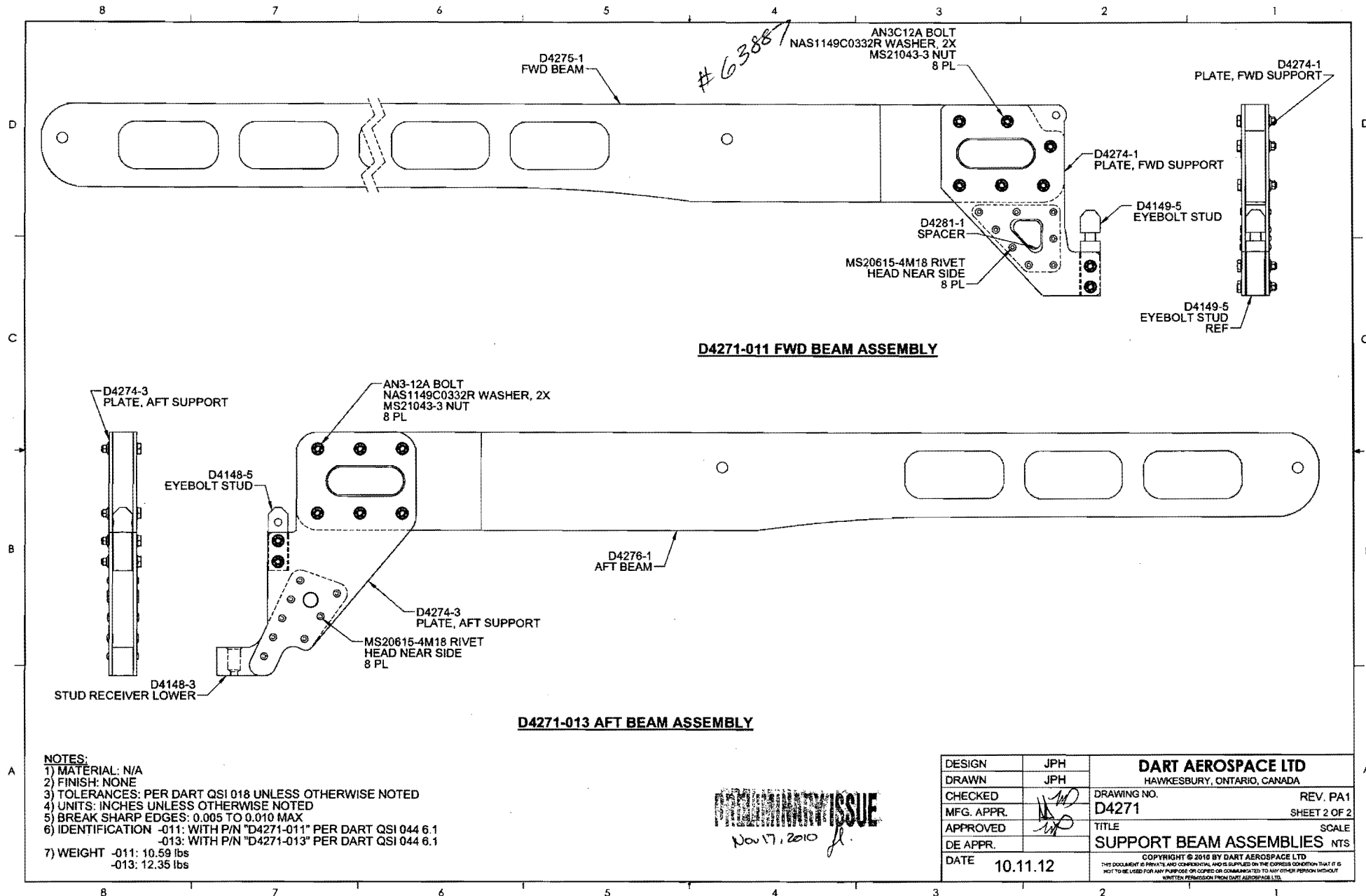
**D4271-011 FWD BEAM ASSEMBLY**



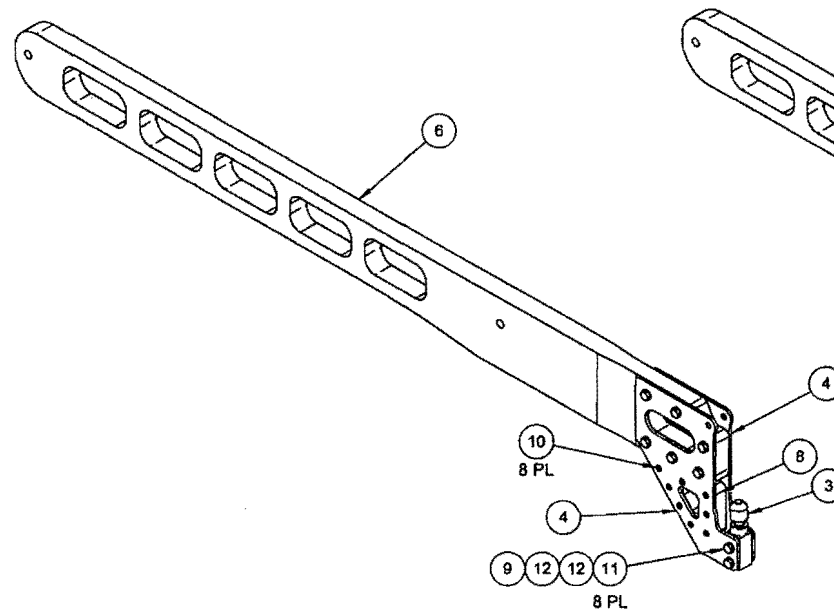
**D4271-013 AFT BEAM ASSEMBLY**

**PRELIMINARY ISSUE**  
Nov 17, 2010 fl.

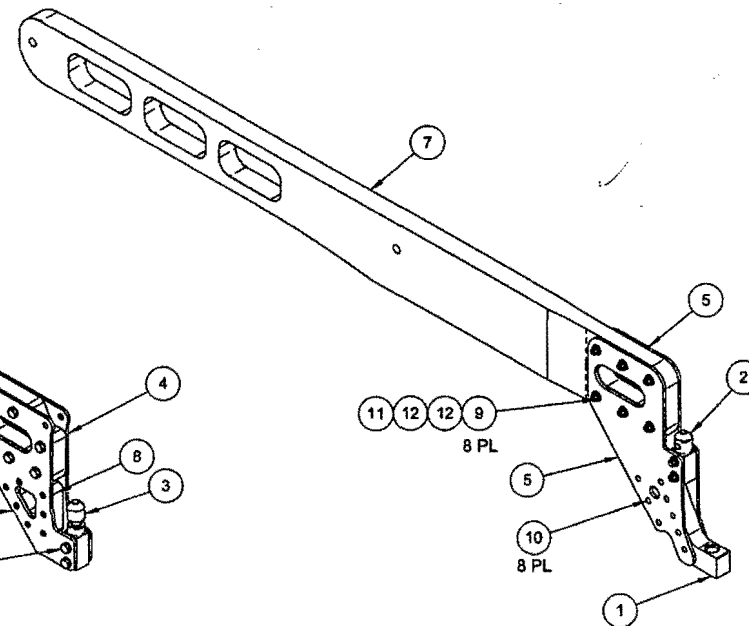
PA1	PRELIMINARY	JPH	10.11.12
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. PA1
MFG. APPR.	JPH	D4271	SHEET 1 OF 2
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	SUPPORT BEAM ASSEMBLIES	NTS
DATE	10.11.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



ITEM	QTY -011	QTY -013	PART NUMBER	DESCRIPTION
			D4271-011	FWD BEAM ASSY
			D4271-013	AFT BEAM ASSY
1		1	D4148-3	STUD RECEIVER
2		1	D4148-5	EYEBOLT STUD
3	1		D4149-5	EYEBOLT STUD
4	2		D4274-1	PLATE, FWD SUPPORT
5		2	D4274-3	PLATE, AFT SUPPORT
6	1		D4275-1	FWD BEAM
7		1	D4276-1	AFT BEAM
8	1		D4281-1	SPACER
9	8	8	AN3C12A	BOLT
10	8	8	MS20615-4M18	RIVET
11	8	8	MS21043-3	NUT
12	16	16	NAS1149C0332R	WASHER



**D4271-011 FWD BEAM ASSEMBLY**



**D4271-013 AFT BEAM ASSEMBLY**

A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4271</b> TITLE <b>SUPPORT BEAM ASSEMBLIES</b> SCALE <b>NTS</b>	
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.25		

REV. A  
SHEET 1 OF 2

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